

Work Order ID 81861

\*81861\*

Page 1

Tuesday, March 20, 2012 9:27:12 AM

Item ID: D350-591-311

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan:

*X*

Date: 12-03-20 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3272	Rev B								

100

\*100\*

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

NON EUROCOPTER

*Sirball* ④

*HJ for MJS 12-4-17*

④

110

\*110\*

Large Fab

0.00

*12-04-03 t p*

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod *119735*  
*120169*

3-Grind End Plate flush

*→ Ac 12-04-05*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 81861**

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Page 2

**Item ID:** D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Heli-Access-Step, Long LH

Stop

**\*NS2\***

**Start Date:** 3/20/2012 **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 3/27/2012 **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:** Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

120

**\*120\***

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

4 0 BE 12/04/05

130

**\*130\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Signature

4 0

140

**\*140\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

AE 12.04.05

x4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QC:

Date:

SPC (Y/N):

Date:

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Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Quality Control

x 4

M.  
12.04.12

180

Large Fab

0.00

**\*180\***

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

4 8 Ae 12.04.12  
ll

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272  
A/RAluminum Rod 119785

6-Grind End Plate flush

7-Install last rivet as per Dwg.

Dart Aerospace Ltd

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Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

**\*190\***

QC

Quality Control

S120713

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Quality Control

S120713

+4  
-4

210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

Hand Finishing

0.00

4X ✓

MF  
12/04/13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date: \_\_\_\_\_

Run

Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

**\*220\***

Powdercoat

Powder Coating

M120222

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

HX ✓

ML 12/04/13

230

**\*230\***

HandFinish

Hand Finishing

Memo

2:45 0.00  
START TIME: 320°F  
OVEN TEMPERATURE:  
FINISH TIME: 3:15

Wing Walk as per dwg QSI005 4.4 Batch 120902

0.00

LHX

240

**\*240\***

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00 8/24/09

+4  
-4

AP 12/04/17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals: Process Plan:

Date:

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

**\*250\***

Packaging

Pick Kit

0.00

4

12/04/18

Packaging

Memo

0.00

260

**\*260\***

QC

QC4- 100% Inspect kits for completeness

0.00

3/26/18

xy

Quality Control

Memo

0.00

LA

270

**\*270\***

Packaging

Packaging

0.00

4X

Packaging

Memo

0.00

SP  
12/04/20Identify and pack for shipping as per PPPD350-591-311  
Location: FG012

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup

Start

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Required Date: 3/27/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Quality Control

Memo

0.00

12/4/19

MK  
12.04.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

## Picklist Print

*Tuesday, March 20, 2012 9:27:29 AM*

Page 1

**Work Order ID:** 81861

**Parent Item:** D350-591-311

**Parent Item Name:** Heli-Access-Step, Long LH

\*81861\*  
\*D350-591-311\*

**Start Date:** 3/20/2012

**Required Date:** 3/27/2012

**Start Qty:** 4.00

**Required Qty:** 4.00

**Comments:** IPP Rev:A04.03.22New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified  
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 2

Tuesday, March 20, 2012 9:27:30 AM

Work Order ID: 81861

\*81861\*  
\*D350-591-311\*

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3219-1

Manufactured No

110

Each

60.0000

2

8

\*\*

*12.04.03*

\*D3219-1\*

Plate

Location	Loc Qty	Loc Code
WA016 <i>B82059</i>	60	
73410	12	
77674	6	
78763	42	

D3066-1

Manufactured No

180

Each

46.0000

2

8

\*\*

*B81968 X8 Ae 12.04.11*

\*D3066-1\*

Spacer

Location	Loc Qty	Loc Code
WA	46	
78605	46	

MS20600-AD4W4

Purchased No

180

Each

2,518.000

16

64

*121340*

*M+21390*

*Ae 12.04.11*

\*MS20600-AD4W4\*

Rivets

Location	Loc Qty	Loc Code
ST321	2513	
116188	59	
117364	253	
117601	200	
117885	195	
118840	1089	
119860	30	
119883	155	
120308	72	
120769	260	
121011	200	
WA018	5	
116712	5	

**Dart Aerospace Ltd**

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\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3065-041

Manufactured No

180

Each

34.0000

1

4

\*\*

B78798

(x4)

Ac 12-04-11

\*D3065-041\*

Step Leg Assembly Hi

Location	Loc Qty	Loc Code
WA	34	
66149	0	
78799	33	
79336	1	

D3067-1

Manufactured No

180

Each

158.0000

1

4

\*\*

12-04-12

\*D3067-1\*

End Plate

Location	Loc Qty	Loc Code
WA	132	
78608	72	
80881	60	
WA016	26	
67582	2	
68214	1	
79607	23	

AN3-35A

Purchased No

250

Each

247.0000

2

8

\*\*

12/04/18

\*AN3-35A\*

Bolt

Location	Loc Qty	Loc Code
ST353	247	
120187	47	
120644	50	
120717	50	
121068	100	

4x120187

4x121068

**Dart Aerospace Ltd**

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3235-1

Manufactured No

250

Each

145.0000

2

8

✓

\*\* 1

\*D3235-1\*

Mounting Lug

Location	Loc Qty	Loc Code
ST	145	
78787	145	

D3278-041

Manufactured No

250

Each

1.0000

1

4

✓

\*\*

3X 78795 JB

\*D3278-041\*

Support Assembly

Location	Loc Qty	Loc Code
ST481	1	
78794	1	

AN960JD416

NAS1149D0463J Purchased

No

250

Each

14.0000

16

64

✓

\*\*

121255 JB

\*AN960.ID416\*

Washer

Location	Loc Qty	Loc Code
ST351	14	
116289	14	

AN960JD516

NAS1149D0563J Purchased

No

250

Each

0.0000

4

16

✓

\*\*

JB

\*AN960.ID516\*

Washer

AN5-36A

Purchased No

250

Each

162.0000

2

8

✓

\*\*

118614 JB

120418

\*AN5-36A\*

Bolt

Location	Loc Qty	Loc Code
ST340	162	
120187	112	
120731	50	

✓

**Dart Aerospace Ltd**

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D2618

Manufactured No

250

Each

304.0000

2

8

\*\*

\*D2618\*

Bushing

S  
A

Location	Loc Qty	Loc Code
ST012	304	
76130	2	
78537	102	
80474	200	

D2230-3

Manufactured No

250

Each

179.0000

4

\*\*

\*D2230-3\*

Lug

S  
A

Location	Loc Qty	Loc Code
ST480	179	
53881	4	
70973	1	
80009	174	

D2856-400

Manufactured No

250

f

197.2345

1.2

4.8

\*\*

\*D2856-400\*

Abrasion Strip

S  
A

Location	Loc Qty	Loc Code
ST409	197.2345	
63735	0.6696	
68076	0.3149	
71164	8.46	
79551	187.79	

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 6

Tuesday, March 20, 2012 9:27:30 AM

Work Order ID: 81861

\*81861\*  
\*D350-591-311\*

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

MS21042L3

Purchased No

250 Each 3,027.000

2 8

\*\*

\*MS210421 3\*

S Nut  
44

Location	Loc Qty	Loc Code
ST300	3027	
117441	16	
117885	32	
118451	5	
118927	3	
<u>119017</u>	2798	<u>119017</u>
<u>119075</u>	173	

AN4-13A

Purchased No

250 Each 1,357.000

8 32

\*\*

\*AN4-13A\*

S Bolt  
44

Location	Loc Qty	Loc Code
ST357	1357	
119449	59	
120187	398	
120422	500	<u>120422</u>
120770	400	

MS21042L5

Purchased No

250 Each 1,588.000

1 2 8

\*\*

\*MS210421 5\*

S Nut  
44

Location	Loc Qty	Loc Code
ST300	1588	
116105	5	
116548	43	
117611	42	
<u>119109</u>	1498	<u>119109</u>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

Tuesday, March 20, 2012 9:27:31 AM

Work Order ID: 81861

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

\*81861\*  
\*D350-591-311\*

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

250

Each

5,307.000

8

32

\*\*

1

JB

12/04/18

\*MS21042L4\*

Nut

Say

Location	Loc Qty	Loc Code
ST300	5307	
117441	51	
117601	21	
118451	133	
119017	200	
119075	2902	119075
121011	2000	

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

16

\*\*

1

1212V3 JB 12/04/18

\*AN960JD10\*

Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. 'B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *ff*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *Y1001*

*11/2-23-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

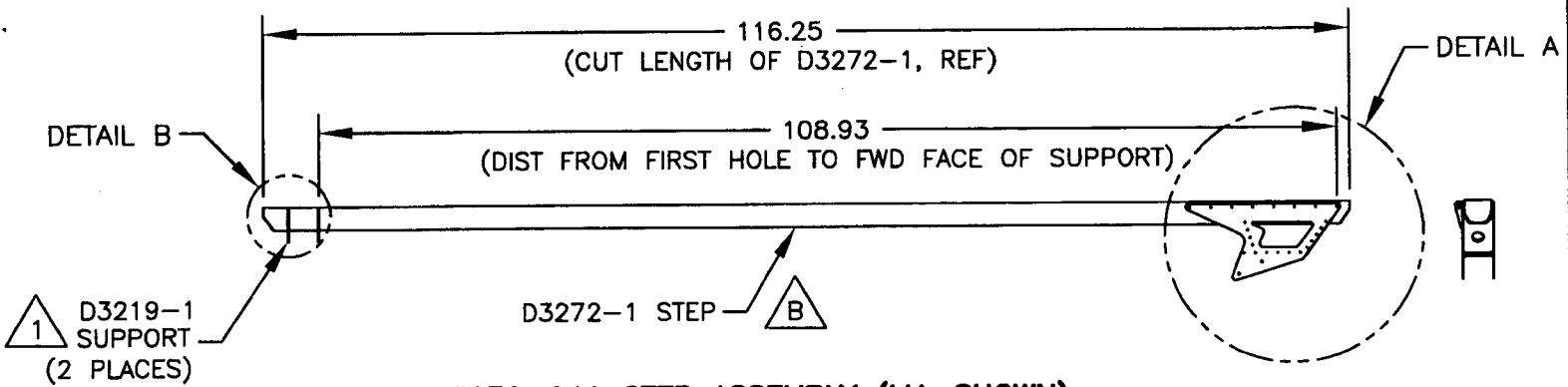
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

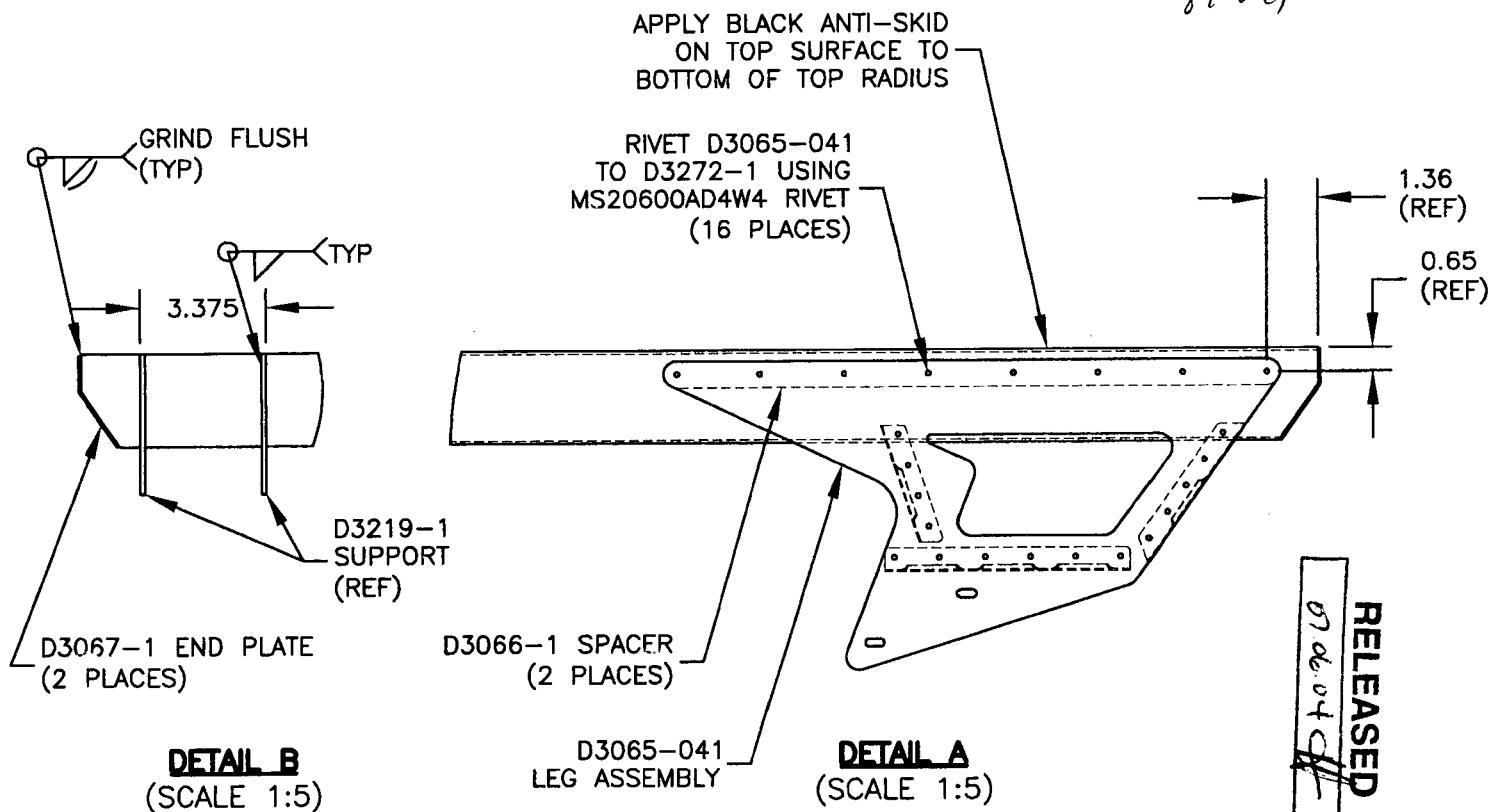
**DART**

DESIGN	90	DRAWN BY	J.B.	DART AEROSPACE LTD
CHECKED	CE	APPROVED	M.H.	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, LH LONG	SHEET 2 OF 3
		SCALE	1:20	SCALE



**D3272-041 STEP ASSEMBLY (LH, SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**

81841



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

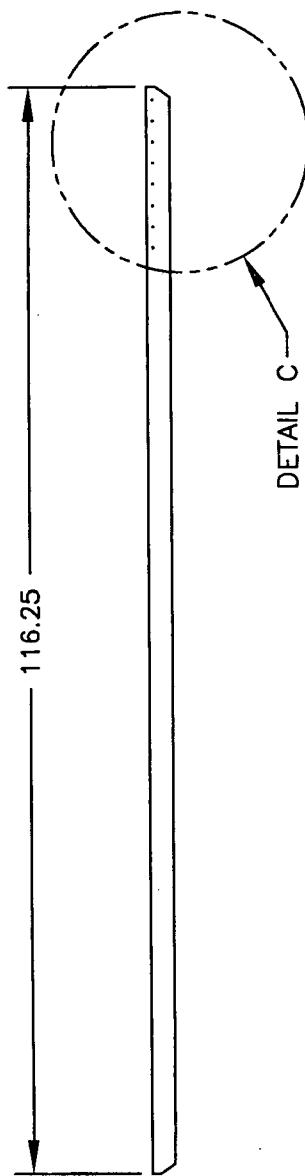
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

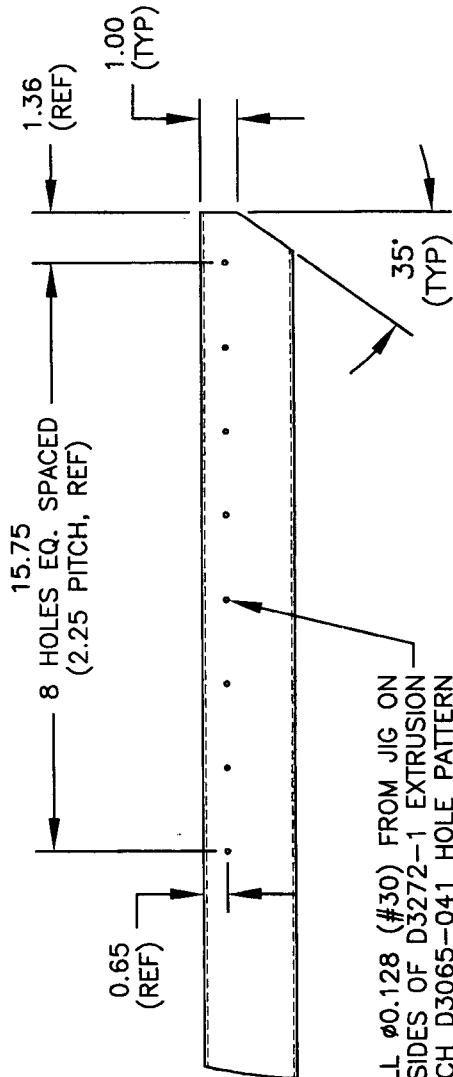
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>ST</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	



**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)

*SI/SLC/*

DRILL #0.128 (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

**RELEASED**  
07.06.04 *[Signature]*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X						D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
			X					D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
				X				D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
					X			D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
						X		D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
1	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	/ 4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						/ 2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	/ 2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						/ 2	2	D3235-1	MOUNTING LUG
						/ 1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	/ 2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						/ 2	2	AN5-36A	BOLT
4	4	4	4	4	4	/ 4	4	AN960JD10	WASHER
20	20	12	12	12	12	-16	16	AN960JD416	WASHER
						/ 4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	/ 8	8	MS21042L4	NUT
						/ 2	2	MS21042L5	NUT
							1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore NOT REQUIRED to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.